

628-033

Work Order ID 72836

Tuesday, August 16, 2011 9:15:54 AM



Item ID:	D2842-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly, 206 Float					
Start Date:	8/16/2011	Start Qty:	4.00	Cust Item ID:		
Required Date:	8/26/2011	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date: 11-08-16	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2842	Rev B								

100
 Large Fab 0.00
 Large Fab Memo 0.00
 Large Fab 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
 2-Drill D2842-1 using Jig DT8271 as per Dwg D2842
 3-Deburr and bevel ends for welding

11-08-26

4 0

110
 QC6- Inspect dimensions to drawing 0.00
 QC Memo 0.00
 Quality Control

11-08-01

4x

120
 Weld per dwg A/R Aluminum rod Batch: 114514 0.00
 Large Fab 117884
 Large Fab Memo 0.00
 Large Fab 1-Weld one end cap and (2) lugs using Jig DT followed by DT as per Dwg D2842
 2-Grind end cap weld flush

11-09-07

4 0

11-09-13

4 0

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Setup Start



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Stop



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 0 BEM 8/14

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulok 14

x4
L4

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11.08.14

4 0

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 BR 11-9-15

170

Weld per dwg A/R Aluminum rod Batch: 114514

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Remove alodine prior to welding.
Weld end cap as per Dwg D2842.
2-Grind end cap weld flush.

11-29-15

4 0

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/20/16

44

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulair 11/6

x4

LH

191

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Touch up step with alodine per qsi 005 prior to powder coat

4X Ø m-L 11/09/16

LHX

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: *10:00*
OVEN TEMPERATURE: *320 OF*
FINISH TIME: *10:30*

4X m-L 11/09/16

LHX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 BR 11-9-19

220

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: 119313 P.

4 BR 11-9-19

230

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/16/11 12:00

xy
224

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

*PP
72837*

646/20 G

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/19/20 JG

*MF
11-09-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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(b) (7)(C), (b) (7)(D)

RESEARCH DESIGN AND METHODS

Required Date: 8/26/2011

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10L	NAS1149C0332	Purchased	No			100	Each	0.0000	3	12		BR 11-9-19.	
<div>  <div>118354.</div> <div>12</div> </div>													
washer													
D2622-120C		Manufactured	No			120	Each	83.7000	1	4		Ac 11-08-26.	
<div>  </div>													
Step Extrusion													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				HALL		74							
					64409	6							
					<u>68293</u>	68							
				WA		9.7							
					46910	2							
					66970	7.7							
D2734		Manufactured	No			120	Each	45.0000	2	8		11-09-15	
<div>  </div>													
Step End Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA	<u>373196</u>	45							
					<u>70701</u>	45							
D3459-3		Manufactured	No			120	Each	21.0000	2	8		11-09-06	
<div>  </div>													
Float Step Mounting Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		21							
					62956	21							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Tuesday, August 16, 2011 9:16:00 AM

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Work Order ID: 72836

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 4.00

Required Qty: 4.00

D3459-1 Manufactured No

220

Each

15.0000

2

8



Float Step Mounting Plate

Location

Loc Qty

Loc Code

WA017 **373319**
62955

15

15

220

Each

53.0000

3

12

MS27039C1-07

Purchased

No



screw

Location

Loc Qty

Loc Code

ST293

53

117423 ✓

53

220

Each

52.0000

3

12

NAS1329C3KB130

Purchased

No



insert

Location

Loc Qty

Loc Code

FP-A

2

115719 ✓

2

ST276

50

117679 ✓

50

220

Each

152.0000

3

12

NAS1515H3L

Purchased

No



WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

112

113362

112

12.

Tuesday, August 16, 2011 9:16:00 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

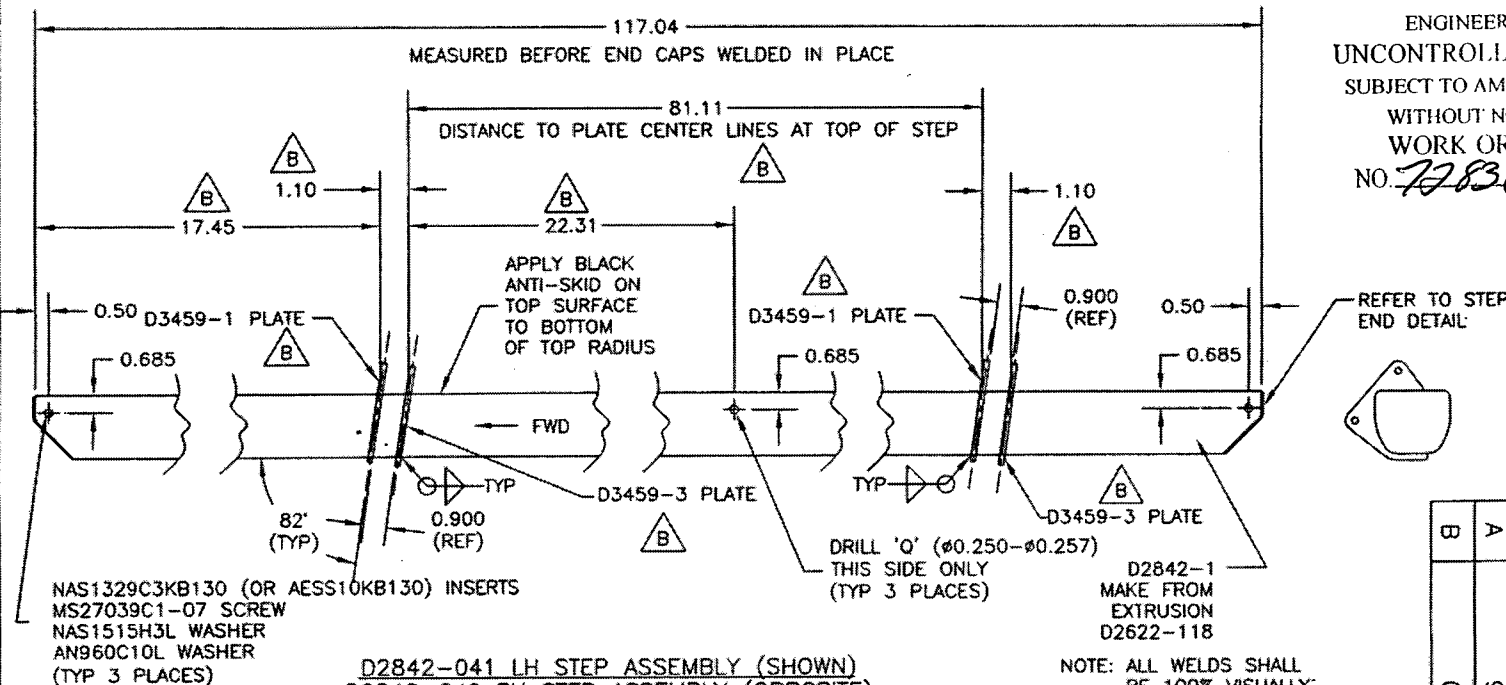
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **72836**

DART



NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

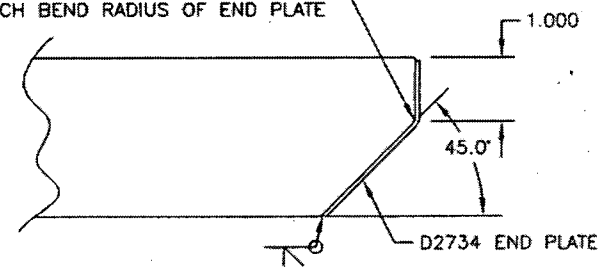
D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
5-11-14

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23	DATE 98.10.13	TITLE 206L/407 FLOAT STEP ASSEMBLY
		NEW ISSUE
		RE-DESIGN, ADD D3459-1/-3
		SCALE NTS
		SHEET 1 OF 1
		REV. B

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